



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G01232-3G-1
Job Sheet 174443



Part No: RBW6305G01232-3G-1

Job Qty: 8 ea

Part Name: Receiver



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/15/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G01232-3G Rev 3 IPP Rev A 18.02.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	6 Ea		4/19/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	6 pcs		4/20/18	0.00	1.50	MORI SL-154		
120	QC	6 pcs		4/20/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs		4/20/18	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs		4/20/18	0.00	0.00	Outsource3		
160	Packaging	6 pcs		4/20/18	0.00	0.00	Packaging2		
170	QC	6 pcs		4/20/18	0.00	0.00	QC6		
180	Packaging	6 pcs		4/20/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea		4/20/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB947 FOLIO REV: 44 DWG REV: 43 2-Deburr

Descriptions: 120 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

150 - -Issue P/O to Groupe Altech: P/O 040622 Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow
-Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750"	.5520 ft (.092 ea)	90-Start up Operation	
	Dia.			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.750	1	13	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 3/15/18 1:18 PM Dart.lajeunesse.marie

Container No: S094812



Part: RBW6305G01232-3G-1

Job No: 174443

Serial No/Batch: S094812

Revision: 3

Inspector:

Exp Date:

Instructions:

36"

1.270

DAS
61
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



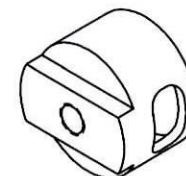
QA Closed: _____ Date: _____

Work Order update only ☐

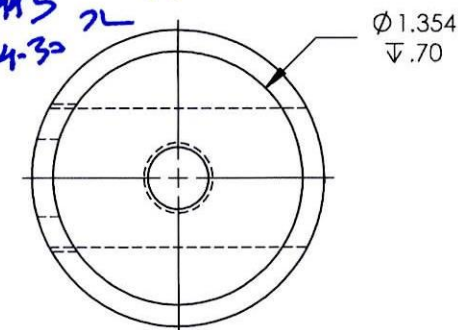
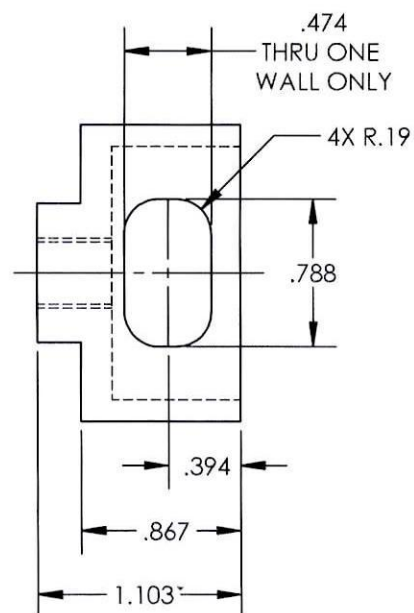
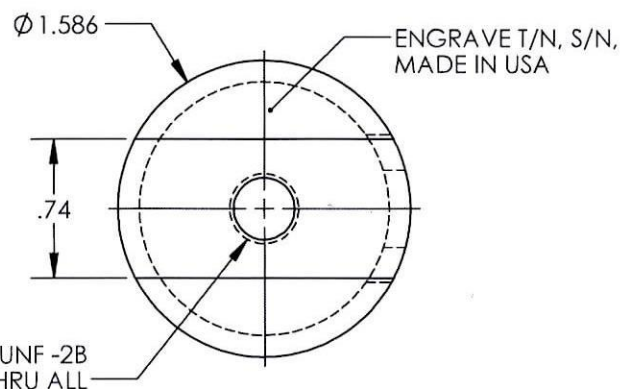
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION					
3	15-0321	-1 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.			10/2/2015	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17443 164-30 1802



(-1)
RECEIVER

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G-1	REV 3
MAT'L 4140 Q&T / 4142 Q&T	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH CAD PLATE YELLOW
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC QQ-P-416, TYPE II, CLASS II USED ON MODEL AGUSTA
SCALE 1:1	DATE 4/7/2011 SHEET 2 OF 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance

(011405-3)

Bon de Livraison / Packing Slip

011405- 3

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
02-Aug-2018		Jessie Boisvert		040622				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6305G01232-3G-1 Rev. ✓	RBW6305G01232-3G-1 Q1 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F type 2 class 2 and bake DAS 61 9-89	CADMIUM CH	12	12 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040622**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040622
PO Date: 7/27/18
Due Date: 7/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174443	RBW6305G01232-3G-1	Receiver -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/31/18	12 pcs	0 pcs	12 pcs	\$14.5833333/pcs	\$175.00
							12x	AUG 03 2018			
2	178201	RBEM262V3000101-21	Plate -Issue P/O to GROUPE ALTECH: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	7/31/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
3	179860	SWA3-300	Wire Clamp -Issue P/O to Groupe Altech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/31/18	19 pcs	0 pcs	19 pcs	\$6.31578947/pcs	\$120.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178356	RBT400221-109	Turnbuckle -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type Stress Proof; -Certificate of Conformity is required	Firmed	-	7/31/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
							12 X	AUG 03 2018			
5	181471	C10-6	Trunnion 1-Issue P/O to Groupe Altech; P/O _____ RC 44-46 2-Nickel plate - 0.0009-0.0011, Bake after plating 3- Certificate of Conformity is required	Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
							1 X	AUG 01 2018			
6	179961	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	7/31/18	2 pcs	0 pcs	2 pcs	\$60.00/pcs	\$120.00
7	180205	RBW6205G19332-3G-1	Draw Bolt -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	7/31/18	7 pcs	0 pcs	7 pcs	\$12.8571429/pcs	\$90.00
							7 X	AUG 03 2018			
8	177589	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	-	7/31/18	20 pcs	0 pcs	20 pcs	\$5.00/pcs	\$100.00
							20 X	AUG 03 2018			
Grand Total:											\$1,085.00

Order Notes

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material Identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/18 2:34 PM dart.tsimikis.chrisoula